CLAIM AMENDMENTS:

1. (canceled)

2. (canceled)

3. (canceled)

4. (canceled)

5. (canceled)

6. (new) A laser welding method, which comprises:

supplying a filler wire to a welding object portion, and

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welding the welding object portion by immediate physical irradiation of the welding object portion by a laser beam from a laser source;

wherein the filler wire is supplied obliquely from forward or backward in a welding advance direction such that an angle between the supplying direction of the filler wire and a beam axis of the laser beam is less than 45°.

7. (new) A laser welding method as claimed in claim 6, wherein the filler wire is supplied from backward of the laser beam with respect to the welding advance direction.

8. (new) A laser welding method as claimed in claim 6, wherein the laser beam is a focused laser beam. C 10 L 19-30

9. (new) A laser welding method as claimed in claim 6, wherein the laser beam is supplied in a direction substantially perpendicular to a welding advance direction. Same as 10

10. (new) A laser welding method, which comprises:

supplying a filler wire to a welding object portion, and

welding the welding object portion by irradiation with a laser beam, including weaving the laser beam in a direction substantially perpendicular to a welding advance direction;

B) wherein the filler wire is supplied obliquely from forward or backward in the welding advance direction such that an angle between the supplying direction of the filler wire and a beam axis of the laser beam is less than 45°.

11. (new) A laser welding method as claimed in claim 10, wherein the filler wire is supplied from backward of the laser beam with respect to the welding advance direction.

12. (new) A laser welding method as claimed in claim 10, wherein the welding is carried out satisfying the following relationship:

$$Vw/F \leq 2D/\sin\theta$$

where θ is an angle between the beam axis L of the laser beam and a supplying direction of the filler wire, D is key hole diameter, Vw is a supplying speed of the filler wire, and F is a weaving frequency of the laser beam.